

# Work Order ID 63851



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Tuesday, November 16, 2010 2:31:22 PM

Item ID: D350-636-012

Accept



Setup Start



Revision IP:

Stop



Item Name: Skidtube RH

Start Date: 11/16/2010 Start Qty: 1.00

Required Date: 11/30/2010 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: *R*Date: *10/17/14*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
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Draw Nbr

Revision Nbr

IIN-D350-636

H

0.00

100



DC

DOCUMENT CONTROL

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

*Swkzlos**For BG 10-12-7**B63851*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
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NOTE: Date & initial all entries

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

110

0.00



Skidtubes

Skidtubes

**Memo**

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 &amp; DT8863A for first side only DT8863B for second side (detail K)

7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.  
\*\*\*SECOND SIDE\*\*\*

8-Open up holes for Detail B to 0.375" (4 holes per side) and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up holes for ground handling and detail L to 0.500" (8 holes per side)

9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

10-Open up holes of Detail A to 0.297" (total of 2 holes per side)

BB  
10/11/22

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|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004  
A/R Aluminum Rod batch: M115778 BE 10/11/22

12-Grind welds flush as per Dwg D2750 BE 10/11/23

120



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

S 10/11/23

Memo

0.00

130



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

S 10/11/23

Memo

0.00

(X)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start  
Stop

| Sequence ID/<br>Work Center ID  | Operation<br>Description                            | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp  |
|---|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|---|
| 140<br><br>HandFinish<br>Hand Finishing | Chemical Conversion Coat per QSI005 4.1<br><br>Memo | 0.00<br><br>0.00     |         |        |              | 1             | 0             | BE10/11/23       |   |
| 150<br><br>QC<br>Quality Control       | QC3- Inspect Part Finish<br><br>Memo                | 0.00<br><br>0.00     |         |        |              |               |               |                  |  10-11-23 |

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QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
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160

0.00



Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐ Sikaflex-291 batch: M116040 ☐ ☐ ☐  
exp. date: 11-9-30

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 &amp; QSI004 (welding instructions on sheet 9)

A/R ☐ Aluminum Rod batch: M115778

9- At section AP-AP drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

11-Spot face ground handling holes section (total of 4 places per side) as per

BE 10/11/23

BE 10/11/24  
BB 10/11/25  
BE 10/11/25

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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**NOTE:** Date & initial all entries

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Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
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|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

dwg D2750

12-Deburr holes

*BE 10/11/25*

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

*Solul26*

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

*Solul26*

*(Signature)*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



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|      |      |                                  |                             |                                 |                |                           |                       |                          |
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QC:

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Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

220

0.00



HandFinish

Hand Finishing

HandFinishing

Memo

✓ Install inserts as per dwg D2750

0.00

230

0.00



HandFinish

Hand Finishing

HandFinishing

Memo

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3"  
batch: N/A3-Install blade fitting D3488-042, wearshoes and ground handling hardware as  
per dwg D2750

SIKA FLEX 241

✓ BATCH: M115114  
EXP DATE: 11101

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

✓ A/R 55-o'ring lube batch: M114189

5-Coat all exposed fasteners with "LPS Procyon"

✓ batch: M114596

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
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Run Start  
Stop

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|---|---|----------------------|---------|--------|--------------|---|---------------|------------------|----------------|
| 240<br><br>QC<br>Quality Control   | QC5- Inspect part completeness to step on W/O<br><br>Memo | 0.00<br>0.00         |         |        |              |    |               |                  |                |
| 250<br><br>Packaging<br>Packaging | Pick Kit<br><br>Memo                                      | 0.00<br>0.00         |         |        |              |   |               |                  |                |
| 260<br><br>QC<br>Quality Control | QC4- 100% Inspect kits for completeness<br><br>Memo       | 0.00<br>0.00         |         |        |              |  |               |                  |                |

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|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 63851**

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Page 10

Item ID: D350-636-012

Accept

Setup Start

Revision ID:

Stop

Item Name: Skidtube RH

Start Date: 11/16/2010 Start Qty: 1.00

Cust Item ID:

Required Date: 11/30/2010 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

Stop

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

270

0.00



Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

72  
NED

280

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/12/08

MF

10-12-08

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 63851

Parent Item: D350-636-012

Parent Item Name: Skidtube RH



Start Date: 11/16/2010

Required Date: 11/10/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev: I 02.09.25 Rearranged procedure steps KJ  
 IPP Rev: J 06-03-29 As per Rev D EC  
 IPP Rev: K 06-07.13 As per dsi9343 EC  
 IPP Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM Verified By: EC  
 IPP Rev: M 08-04-22 update steps 4,13 DD verified by: EC  
 IPP Rev: N 08-09-23 revF as per dwg DD verified by: ec IPP Rev: O  
 10.06.22 revise seq110 DD verf: EC IPP Rev: P 10.10.01 as  
 per IIN revH DD verf: EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand  | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|----------------|--------|
| ALS4-1032-225<br>               |                        | Purchased     | No          |                     |                  | 220             | Each               | 4,520.000       | 38          | 38           |               |                |        |
| Insert                          |                        |               |             |                     |                  |                 |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | PK011               |                  | 4520            |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 110768              |                  | 4520            |                    |                 |             | x38          |               |                |        |
| AN3C5A<br>                      |                        | Purchased     | No          |                     |                  | 230             | Each               | 888.0000        | 34          | 34           |               |                |        |
| Bolt                            |                        |               |             |                     |                  |                 |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  | <u>Loc Qty</u>  |                    | <u>Loc Code</u> |             |              |               |                |        |
|                                 |                        |               |             | ST350               |                  | 878             |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 114330              |                  | 11              |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 115015              |                  | 13              |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 115371              |                  | 100             |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 115422              |                  | 100             |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 115594              |                  | 282             |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 115835              |                  | 372             |                    |                 |             | x34          |               |                |        |
|                                 |                        |               |             | ST351               |                  | 10              |                    |                 |             |              |               |                |        |
|                                 |                        |               |             | 113121              |                  | 10              |                    |                 |             |              |               |                |        |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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Page 2

Work Order ID: 63851

Parent Item: D350-636-012



Parent Item Name: Skidtube R

Start Date: 11/16/2010

Required Date: 11/30/2010



Start Qty: 1.00

Required Qty: 1.00

|   |           |    |     |      |          |   |             |
|---|-----------|----|-----|------|----------|---|-------------|
| AN3C6A  | Purchased | No | 230 | Each | 245.0000 | 4   | 4           |
|  |           |    |     |      |          |  | yl 10/12/06 |
| BOLT  |           |    |     |      |          |   |             |



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

|        |     |  |
|--------|-----|--|
| ST351  | 245 |  |
| 111982 | 245 |  |

|   |           |    |     |      |          |   |             |
|---|-----------|----|-----|------|----------|---|-------------|
| AN6C44A   | Purchased | No | 230 | Each | 119.0000 | 4   | 4           |
|  |           |    |     |      |          |  | yl 10/12/06 |
| BOLT  |           |    |     |      |          |   |             |



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

|        |     |  |
|--------|-----|--|
| FG     | 2   |  |
| 103964 | 2   |  |
| ST344  | 117 |  |
| 111649 | 2   |  |
| 114653 | 1   |  |
| 114941 | 64  |  |
| 115936 | 50  |  |

|  |           |    |     |      |         |  |             |
|--|-----------|----|-----|------|---------|--|-------------|
| AN8C35A  | Purchased | No | 230 | Each | 54.0000 | 1  | 1           |
|  |           |    |     |      |         |  | yl 10/12/06 |
| BOLT   |           |    |     |      |         |  |             |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

|        |    |  |
|--------|----|--|
| ST346  | 54 |  |
| 114442 | 5  |  |
| 115188 | 22 |  |
| 115960 | 27 |  |

|   |              |           |    |     |      |   |             |    |
|---|--------------|-----------|----|-----|------|---|-------------|----|
| AN960C10L   | NAS1149C0332 | Purchased | No | 230 | Each | 25.0000   | 38          | 38 |
|  |              |           |    |     |      |  | yl 10/12/06 |    |
| washer  |              |           |    |     |      |   |             |    |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
|-----------------|----------------|-----------------|

|        |    |  |
|--------|----|--|
| ST245  | 25 |  |
| 107534 | 25 |  |

M115832 y38

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 63851

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C816L

Purchased No

230

Each

0.0000

1

1



NAS1149C08332R/M114915 X



xl M 10/12/06

WASHER

D2745

Manufactured No

230

Each

265.0000

8

8



M 10/12/06

Bushing

## Location

## Loc Qty

## Loc Code

ST023

265

52311

5

59112

4

61203

44

61988

104

63315

108

VS

D3488-042

Manufactured No

230

Each

24.0000

1

1



M 10/12/06

Blade Fitting Assembly, RH

## Location

## Loc Qty

## Loc Code

FP008

15

59643

5

62003

10

FP18

9

61690

9

xl

D3492-041

Manufactured No

230

Each

76.0000

8

8



M 10/12/06

Plug Assembly

## Location

## Loc Qty

## Loc Code

FP013

76

59114

1

61987

14

62210

61

VS

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Page 3

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Page 4

Work Order ID: 63851

Parent Item: D350-636-012



Parent Item Name: Skidtube P

Start Date: 11/16/2010



Required Date: 11/30/2010

Start Qty: 1.00



Required Qty: 1.00

D3492-043      Manufactured      No      230      Each      85.0000      8      8  
  10/12/06  
 Plug Assembly



| Location     | Loc Qty | Loc Code |
|--------------|---------|----------|
| FP           | 2       |          |
| 54682        | 2       |          |
| FP013        | 83      |          |
| 59117        | 1       |          |
| 59190        | 4       |          |
| <u>62663</u> | 78      |          |

D3535-25      Manufactured      No      230      Each      21.0000      1      1  
  10/12/06  
 Wearshoe

| Location     | Loc Qty | Loc Code |
|--------------|---------|----------|
| FP18         | 21      |          |
| 62033        | 7       |          |
| <u>62233</u> | 14      |          |

D3536-25      Manufactured      No      230      Each      4.0000      1      1  
  10/12/06  
 Gasket

| Location     | Loc Qty | Loc Code |
|--------------|---------|----------|
| FP12         | 4       |          |
| <u>61707</u> | 4       |          |

D3537-1      Manufactured      No      230      Each      18.0000      3      3  
  10/12/06  
 Wearpad

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| FP017    | 18      | B62928   |
| 62661    | 9       | B63545   |
| 63313    | 9       |          |

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 63851

Parent Item: D350-636-012



Parent Item Name: Skidtube R1.

Start Date: 11/16/2010



Required Date: 11/30/2010

Start Qty: 1.00



Required Qty: 1.00

|   |              |    |     |      |          |   |                 |
|---|--------------|----|-----|------|----------|---|-----------------|
| D3631-1   | Manufactured | No | 230 | Each | 281.0000 | 8   | 8               |
|  |              |    |     |      |          |  | <u>8</u>        |
| Washer  |              |    |     |      |          |   | <u>10/12/06</u> |



| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST072           | 281            |                 |
| <u>60755</u>    | 81             | <u>x8</u>       |
| 63647           | 200            |                 |

|   |              |    |     |      |          |   |                 |
|---|--------------|----|-----|------|----------|---|-----------------|
| D3672-1   | Manufactured | No | 230 | Each | 665.0000 | 4   | 4               |
|  |              |    |     |      |          |  | <u>4</u>        |
| Phenolic Washer   |              |    |     |      |          |   | <u>10/12/06</u> |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| ST077           | 665            |                 |
| 42329           | 10             | <u>vd</u>       |
| <u>52505</u>    | 655            |                 |

|   |              |    |     |      |         |   |                 |
|---|--------------|----|-----|------|---------|---|-----------------|
| D3791-1   | Manufactured | No | 230 | Each | 19.0000 | 1   | 1               |
|  |              |    |     |      |         |  | <u>1</u>        |
| Wearplate   |              |    |     |      |         |   | <u>10/12/06</u> |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP17            | 19             |                 |
| <u>61702</u>    | 7              | <u>x1</u>       |
| 62239           | 12             |                 |

|   |              |    |     |      |         |   |                 |
|---|--------------|----|-----|------|---------|---|-----------------|
| D3793-1   | Manufactured | No | 230 | Each | 16.0000 | 1   | 1               |
|  |              |    |     |      |         |  | <u>1</u>        |
| Wearshoe  |              |    |     |      |         |   | <u>10/12/06</u> |

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP18            | 16             |                 |
| 59151           | 1              |                 |
| 59630           | 1              |                 |
| 61244           | 1              |                 |
| <u>61710</u>    | 13             | <u>x1</u>       |

Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 63851

Parent Item: D350-636-012

Parent Item Name: Skidtube

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

13.0000

1

1



Wearshoe



10/12/06

Location

Loc Qty

Loc Code

FP18

12

61711

12

FP19

1

57947

1

D3794-1

Manufactured No

230

Each

20.0000

1

1



Gasket



10/12/06

Location

Loc Qty

Loc Code

FP010

20

61704

20

D3794-3

Manufactured No

230

Each

25.0000

1

1



Gasket



10/12/06

Location

Loc Qty

Loc Code

FP10

24

60826

1

61712

23

FP18

1

59153

1

MS21043-6

Purchased No

230

Each

618.0000

4

4



NUT



10/12/06

Location

Loc Qty

Loc Code

ST301

618

112314

618

X4

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Page 7

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Work Order ID: 63851

Parent Item: D350-636-012

Parent Item Name: Skidtube R.1

Start Date: 11/16/2010

Required Date: 1./30/2010

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

230

Each

87.0000

1

1



NUT



10/12/06

Location

Loc Qty

Loc Code

ST303

87

113845

5

114934

3

115594

29

115884

50

x1

NAS1611-010

Purchased

No

230

Each

309.0000

8

8



O-RING



10/12/06 PTO =>

Location

Loc Qty

Loc Code

FP

309

110715

100

110915

159

115589

50

NAS1611-013

Purchased

No

230

Each

228.0000

8

8



O-RING



10/12/06

Location

Loc Qty

Loc Code

FP

228

115460

100

115589

28

115812

100

x8

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Page 7

| W/O: 63851 |      | WORK ORDER CHANGES   |    |          |     |                                     |                          |
|------------|------|--|----|----------|-----|-------------------------------------|--------------------------|
| DATE       | STEP | PROCEDURE CHANGE   | By | Date     | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
| 10/12/06   | 230  | Replace NAS1611-010 "O" rings for D25941-3 "O" rings<br>M61762 | jd | 10/12/06 | x8  |                                     | S<br>binder              |
|            |      |  |    |          |     |                                     |                          |

Part No: D350-636-012 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, November 16, 2010 2:31:28 PM

Page 8

Work Order ID: 63851

Parent Item: D350-636-012


Parent Item Name: Skidtube .H


Start Date: 11/16/2010

Required Date: 1/30/2010


Start Qty: 1.00


Required Qty: 1.00

AN8C21A Purchased No 250 Each 45.0000 2 2  10/12/10


 BOLT


| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST345    | 45      |          |
| 113558   | 1       |          |
| 114653   | 4       |          |
| 115723   | 40      |          |

AN960JD816 Purchased No 250 Each 123.0000 2 2  10/12/10


 1/2" washer, Alum


| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST348    | 123     |          |
| 106043   | 123     |          |

D2741 Manufactured No 250 Each 25.0000 1 1  10/12/10

 Blade, 350 Skidtube

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST466    | 25      |          |
| 60210    | 25      |          |

D3493-1 Manufactured No 250 Each 36.0000 2 2  10/12/10

 Washer

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST062    | 36      |          |
| 61672    | 36      |          |

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, November 16, 2010 2:31:28 PM

Page 9

Work Order ID: 63851

Parent Item: D350-636-012

Parent Item Name: Skidtube .H

Start Date: 11/16/2010

Required Date: 1/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3532-1

Manufactured No

250 Each

47.0000

2

2



Spacer



10/12/10

Location

Loc Qty

Loc Code

ST065

47

61673

5

62218

42

D3672-13

Purchased No

250 Each

792.0000

2

2



Phenolic Washer



no keys in kits  
8/10/08

Location

Loc Qty

Loc Code

ST077

792

54363

792

MS21083C8

Purchased No

250 Each

87.0000

1

2



NUT



10/12/10

Location

Loc Qty

Loc Code

ST303

87

113845

5

114934

3

115594

29

115884

50

D2600-3-BENT

Manufactured No

110 Each

13.0000

1

1



Extrusion Bent



Location

Loc Qty

Loc Code

LG

13

61634

4

62594

8

62764

1

BB 10/16/10

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Page 9

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Page 10

Work Order ID: 63851

Parent Item: D350-636-012

Parent Item Name: Skidtub RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D2744

Manufactured No

110

Each

39.0000

1

1



Cap

Location

Loc Qty

Loc Code

LG

6

59198

6

ST

33

62715

33

1 BE 11/1/22

D2739

Manufactured No

160

Each

12.0000

1

1



350 I Beam

Location

Loc Qty

Loc Code

LG

12

62563

8

62688

4

1 BE 11/1/23

D2743

Manufactured No

160

Each

150.0000

8

8



Crossbolt Spacer

Location

Loc Qty

Loc Code

LG

150

50281

10

57953

2

59111

31

61844

107

8 BE 10/11/24

D3490-3

Manufactured No

160

Each

39.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

39

60294

1

62668

38

4 BE 10/11/24

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Page 10

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

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Work Order ID: 63851

Parent Item: D350-636-012

Parent Item Name: Skidtut RH

Start Date: 11/16/2010

Required Date: 11/30/2010

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

95.0000

4

4



Cross Bolt Spacer

Location

Loc Qty

Loc Code

LG

95

59424

3

61217

2

62450

90

4

BE 10/11/24

Tuesday, November 16, 2010 2:31:28 PM

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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WITHOUT NOTICE  
WORK ORDER  
NO. 63551

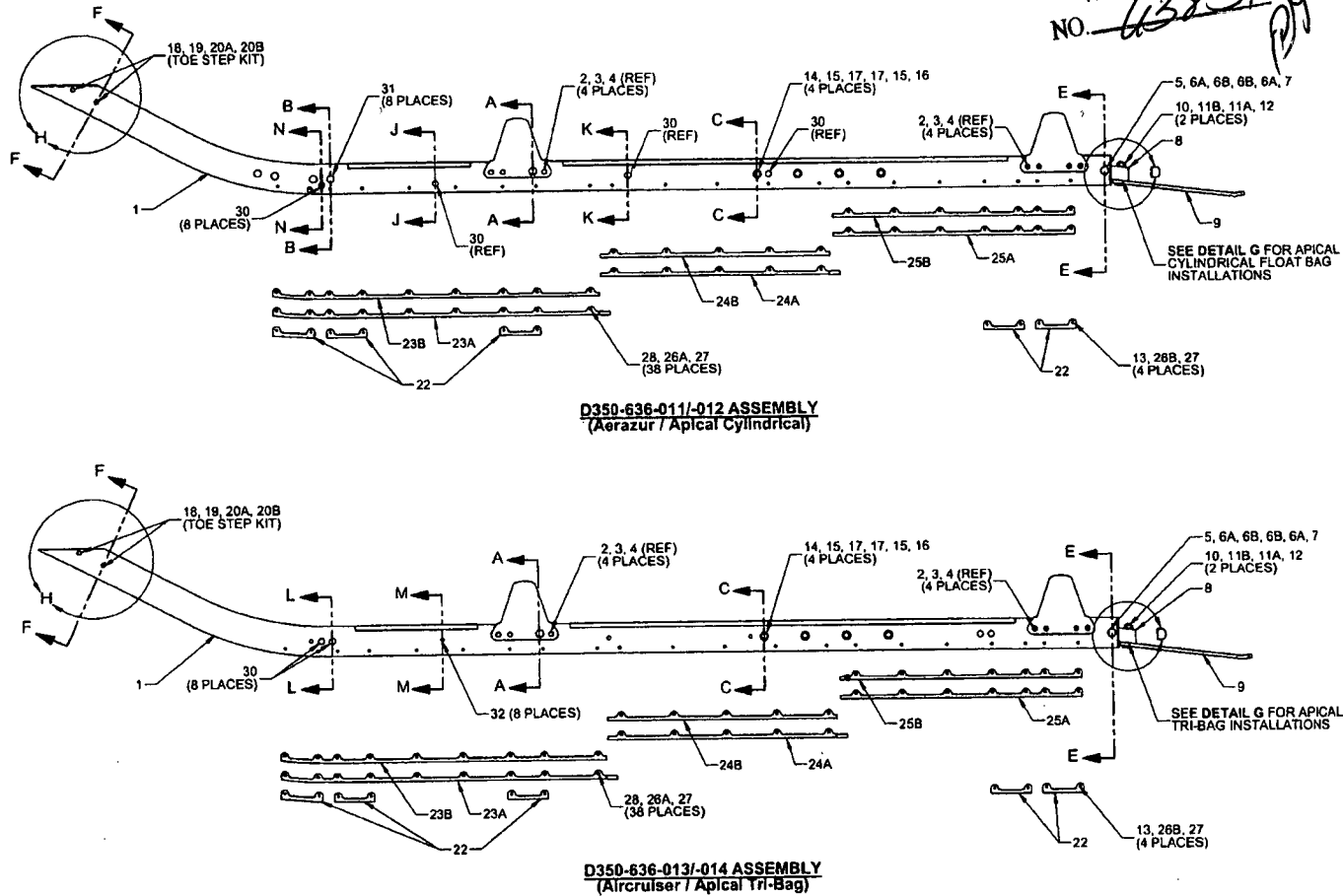
DART AEROSPACE USA, INC.

IIN-D350-636  
Page 11 of 31

Figure 1: D350-636-011/-012/-013/-014 SKIDTUBE ASSEMBLY AT CHG 003

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Revision: H  
Date: 10.07.26



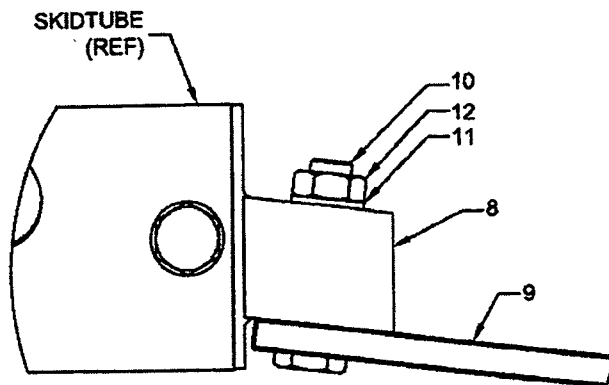
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

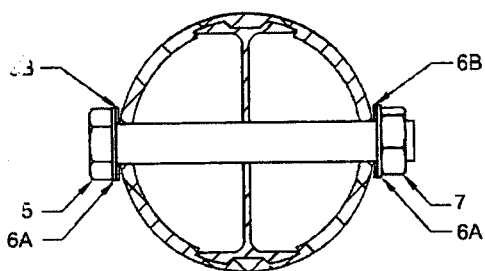
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| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

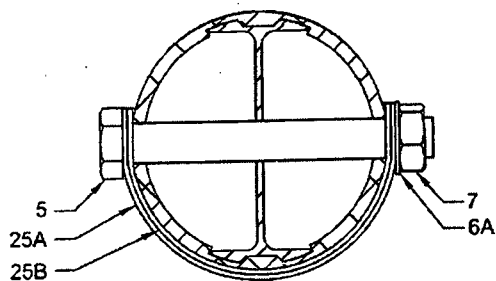
**NOTE:** Date & initial all entries



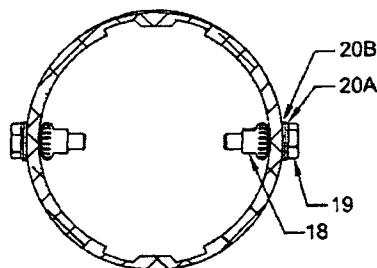
**DETAIL D**  
1 PL PER SKIDTUBE



**SECTION E-E**  
(D350-636-011/-012/-013/-014 SKIDTUBES  
AT CHG 003 ONLY)



**SECTION Q-Q**  
(D350-636-011/-012/-013/-014 SKIDTUBES  
AT CHG 004 OR SUBSEQUENT)



**SECTION F-F**  
2 PL PER SKIDTUBE

u/o 43831

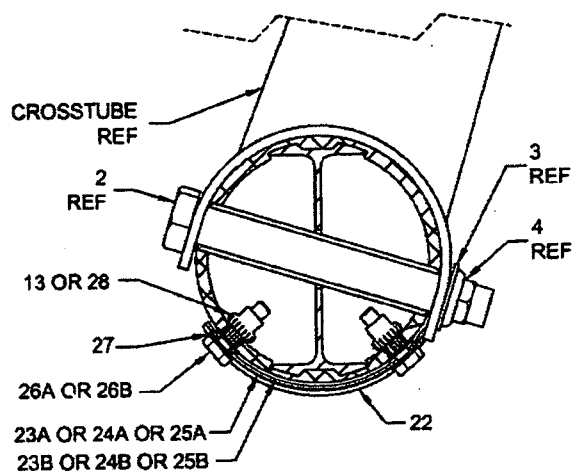
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

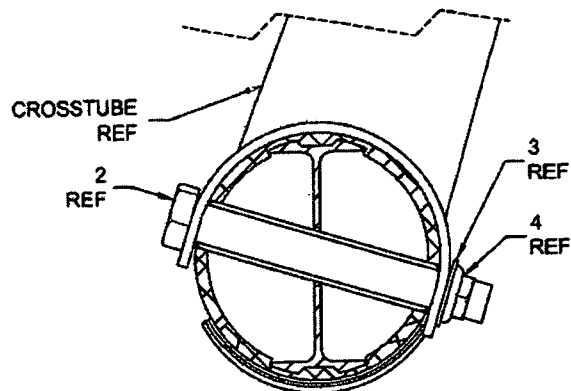
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

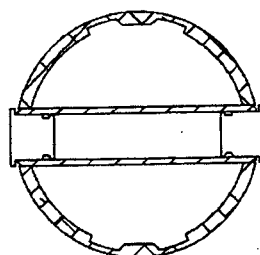
**NOTE:** Date & initial all entries



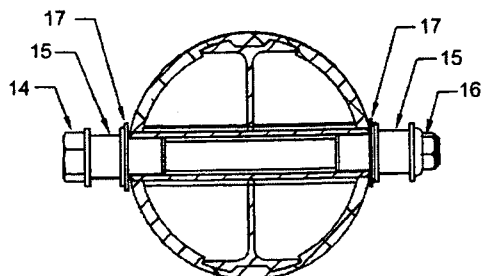
**SECTION A-A**  
(D350-636-011/-012/-013/-014 SKIDTUBES  
AT CHG 003 ONLY)



**SECTION P-P**  
(D350-636-011/-012/-013/-014 SKIDTUBES  
AT CHG 004 OR SUBSEQUENT)



**SECTION B-B**  
(SECTION J-J, K-K, L-L AND M-M SIMILAR)  
8 PL PER SKIDTUBE



**SECTION C-C**  
4 PL PER SKIDTUBE

W/ 63831

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| QTY<br>-041 | QTY<br>-042 | QTY<br>-043 | QTY<br>-044 | PART NUMBER   | DESCRIPTION  |
|-------------|-------------|-------------|-------------|---------------|--|
| X           |             |             |             | D2750-041     | 350 SKIDTUBE ASSEMBLY, LH                                  |
|             | X           |             |             | D2750-042     | 350 SKIDTUBE ASSEMBLY, RH                                  |
|             |             | X           |             | D2750-043     | 350 SKIDTUBE ASSEMBLY, LH                                  |
|             |             |             | X           | D2750-044     | 350 SKIDTUBE ASSEMBLY, RH                                  |
| 1           | 1           | 1           | 1           | D2739         | WEB  |
| 8           | 8           | 8           | 8           | D2743         | SPACER   |
| 1           | 1           | 1           | 1           | D2744         | CAP  |
| 8           | 8           | 8           | 8           | D2745         | BUSHING  |
| 1           |             |             |             | D2750-1       | SKIDTUBE WELDMENT, LH                                      |
|             | 1           |             |             | D2750-2       | SKIDTUBE WELDMENT, RH                                      |
|             |             | 1           |             | D2750-3       | SKIDTUBE WELDMENT, LH                                      |
|             |             |             | 1           | D2750-4       | SKIDTUBE WELDMENT, RH                                      |
| 1           |             | 1           |             | D3488-041     | BLADE FITTING, LH  |
|             | 1           |             | 1           | D3488-042     | BLADE FITTING, RH  |
| 4           | 4           | 4           | 4           | D3490-1       | SPACER   |
| 4           | 4           |             |             | D3490-3       | SPACER   |
|             |             | 4           | 4           | D3490-5       | SPACER   |
| 8           | 8           | 8           | 8           | D3492-041     | PLUG ASSEMBLY  |
| 8           | 8           |             |             | D3492-043     | PLUG ASSEMBLY  |
|             |             | 8           | 8           | D3492-045     | PLUG ASSEMBLY  |
| 1           | 1           | 1           | 1           | D3535-25      | WEARSHOE   |
| 1           | 1           | 1           | 1           | D3536-25      | GASKET   |
| 3           | 3           | 3           | 3           | D3537-1       | WEARPAD  |
| 8           | 8           | 8           | 8           | D3631-1       | WASHER   |
| 1           | 1           | 1           | 1           | D3791-1       | WEARPLATE  |
| 1           | 1           | 1           | 1           | D3793-1       | WEARSHOE   |
| 1           | 1           | 1           | 1           | D3793-3       | WEARSHOE   |
| 1           | 1           | 1           | 1           | D3794-1       | GASKET   |
| 1           | 1           | 1           | 1           | D3794-3       | GASKET   |
| 38          | 38          | 38          | 38          | ALS4-1032-225 | INSERT (OR ALS7-1032-225,<br>AKS4-1032-225, AELS-1032-225) |
| 34          | 34          | 34          | 34          | AN3C5A        | BOLT   |
| 4           | 4           | 4           | 4           | AN3C6A        | BOLT   |
| 4           | 4           | 4           | 4           | AN6C44A       | BOLT   |
| 1           | 1           | 1           | 1           | AN8C35A       | BOLT   |
| 38          | 38          | 38          | 38          | AN960C10L     | WASHER   |
| 1           | 1           | 1           | 1           | AN960C816L    | WASHER   |
| 4           | 4           | 4           | 4           | MS21043-6     | NUT  |
| 1           | 1           | 1           | 1           | MS21083C8     | NUT  |
| 4           | 4           | 4           | 4           | NAS1515H3L    | WASHER   |

# GENERAL NOTES:

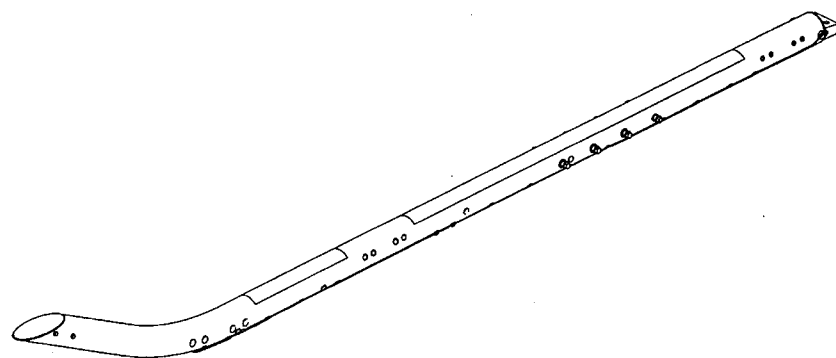
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi 0.297$ ) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF  
POWDER COATING WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

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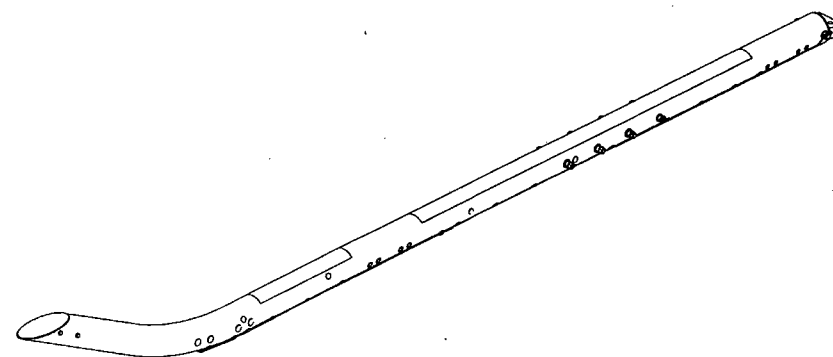
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|            |   |  |               |
|------------|---|--|---------------|
| F          | INCORPORATE DSI 9413;<br>QTY (3) D3537-1 WAS QTY (5) (ZN C8-1);<br>D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1);<br>D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1);<br>ADD D3791-1 (ZN C8-1);<br>WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED<br>(8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1);<br>D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11);<br>ADD NOTE 12 AND 13 (ZN A6-1);<br>REASON: REF. NCK 08-043 | PH   | 08.07.16      |
| E          | CHANGE TO STAINLESS STEEL WEARPLATES;<br>ADD RUBBER GASKETS, CHANGE INSERTS; ADD D3631-1;<br>REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10)<br>NAS1515HBL; REMOVE D2741; QTY (2) AN960C816;<br>REMOVE QTY (2) MS21083C8  | CB   | 07.05.17      |
| D          | ADD HOLES AND SPACERS FOR APICAL FLOATS;<br>INCORPORATE DEC 9133/9157   | PH   | 06.01.05      |
| C          | ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740  | CP   | 98.11.18      |
| B          | CHANGE MS24694-S293 TO AN8-16A  | CP   | 98.09.01      |
| A          | NEW ISSUE   | DS   | 98.04.16      |
| REV.       | DESCRIPTION   | BY   | DATE          |
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| MFG. APPR. | PH  | D2750  | SHEET 1 OF 11 |
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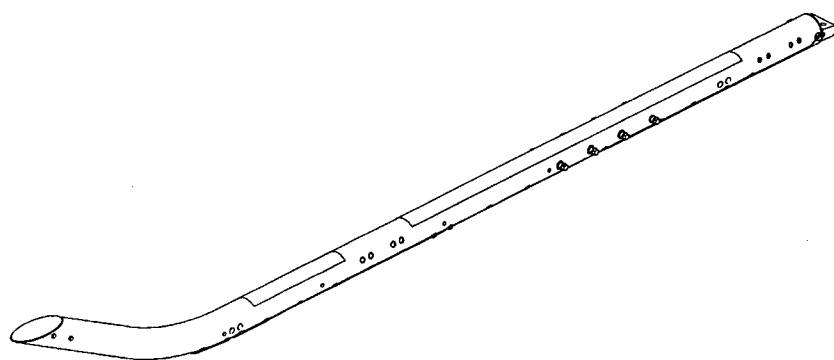
D2750-041 350 SKIDTUBE ASSEMBLY, LH



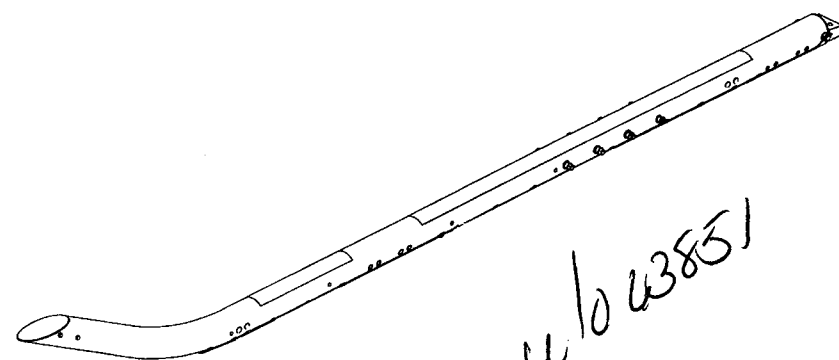
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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| MFG. APPR. | ME       | D2750   | SHEET 2 OF 11 |
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D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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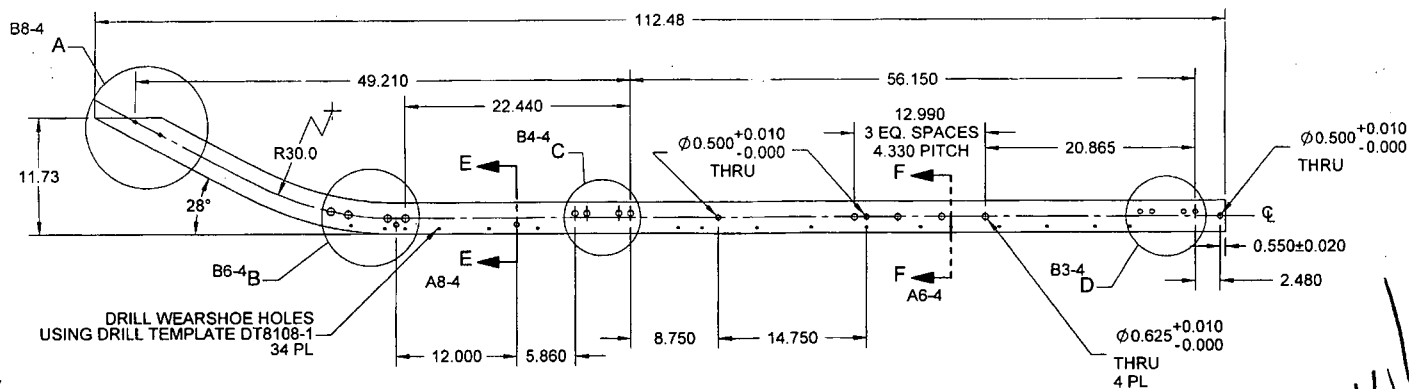
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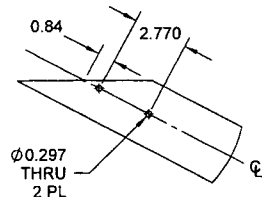
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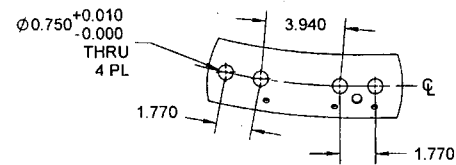
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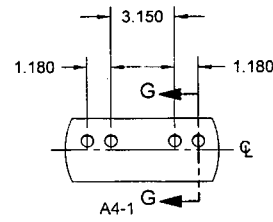
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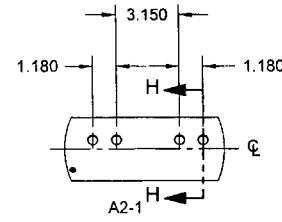
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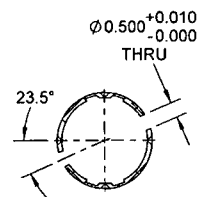
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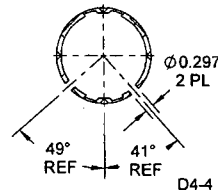
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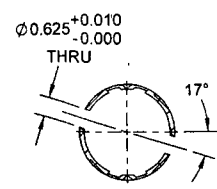
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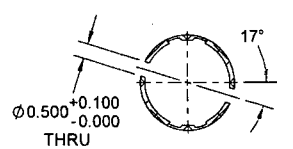
SECTION E-E  
SCALE 3X, 2 PL



SECTION F-F  
SCALE 3X, 17 PL



SECTION G-G  
SCALE 3X, 4 PL



SECTION H-H  
SCALE 3X, 4 PL

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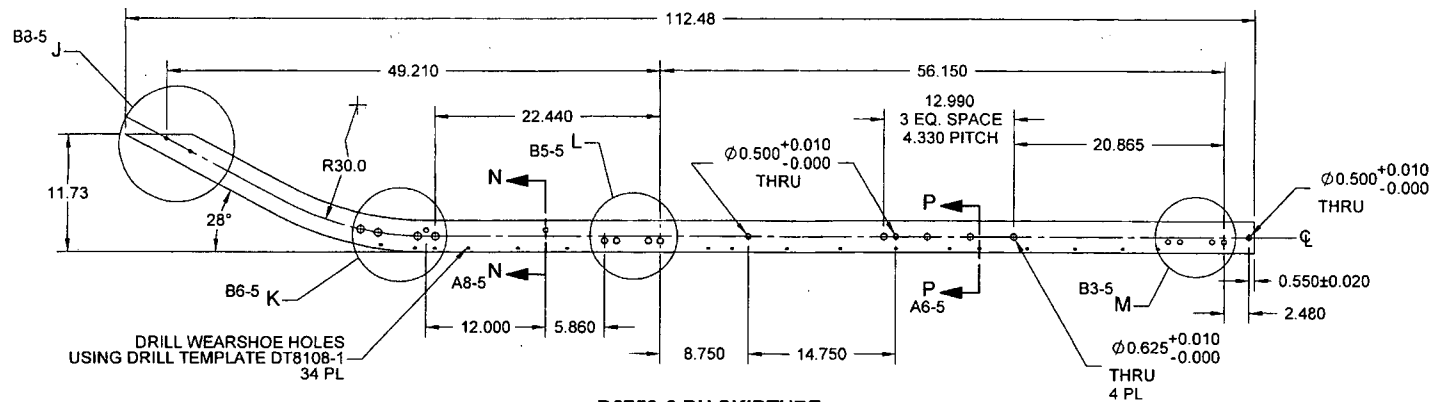
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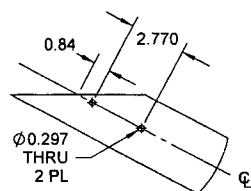
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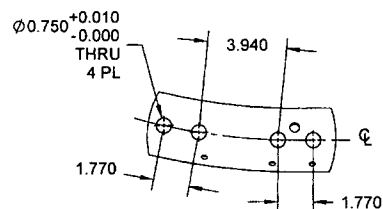
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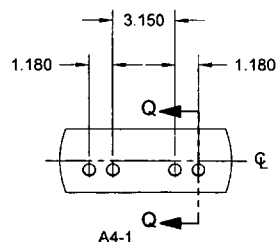
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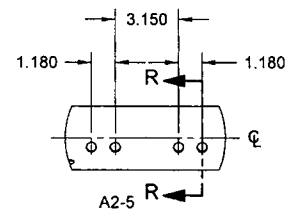
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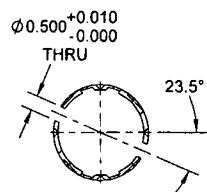
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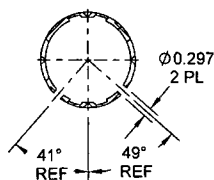
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SCALE 2X



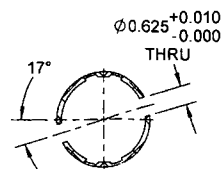
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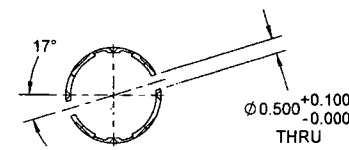
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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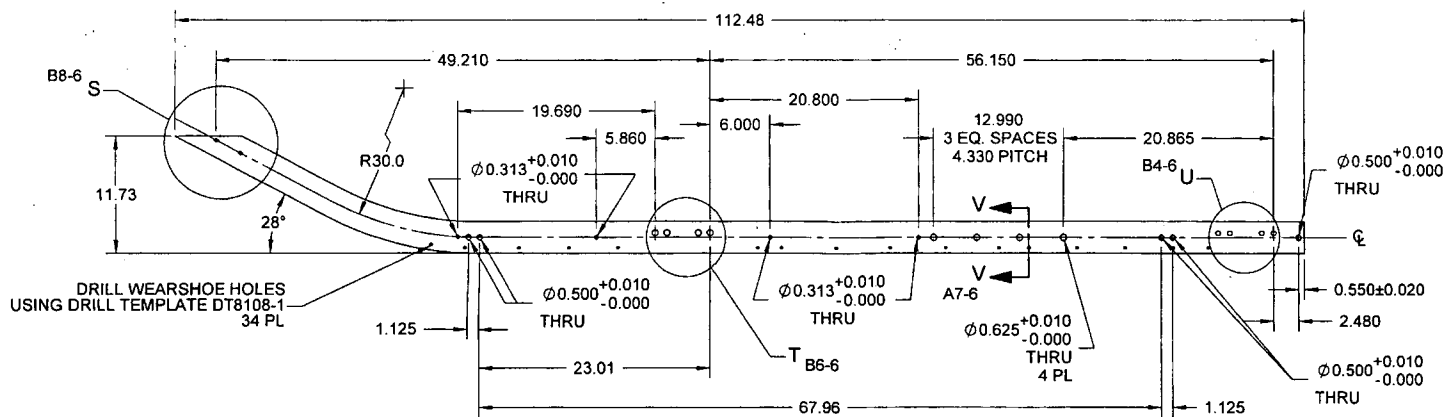
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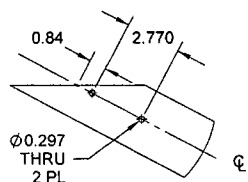
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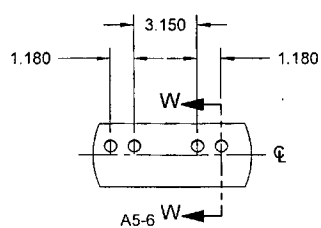
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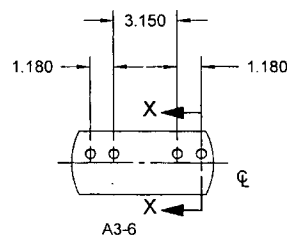
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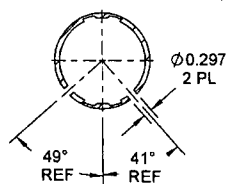
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D8-6  
SCALE 2X



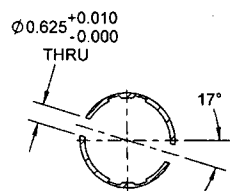
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C5-6  
SCALE 2X



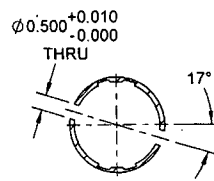
**DETAIL U**  
D3-6  
SCALE 2X



**SECTION V-V**  
C4-6  
SCALE 3X, 17 PL



**SECTION W-W**  
B6-6  
SCALE 3X, 4 PL



**SECTION X-X**  
B4-6  
SCALE 3X, 4 PL

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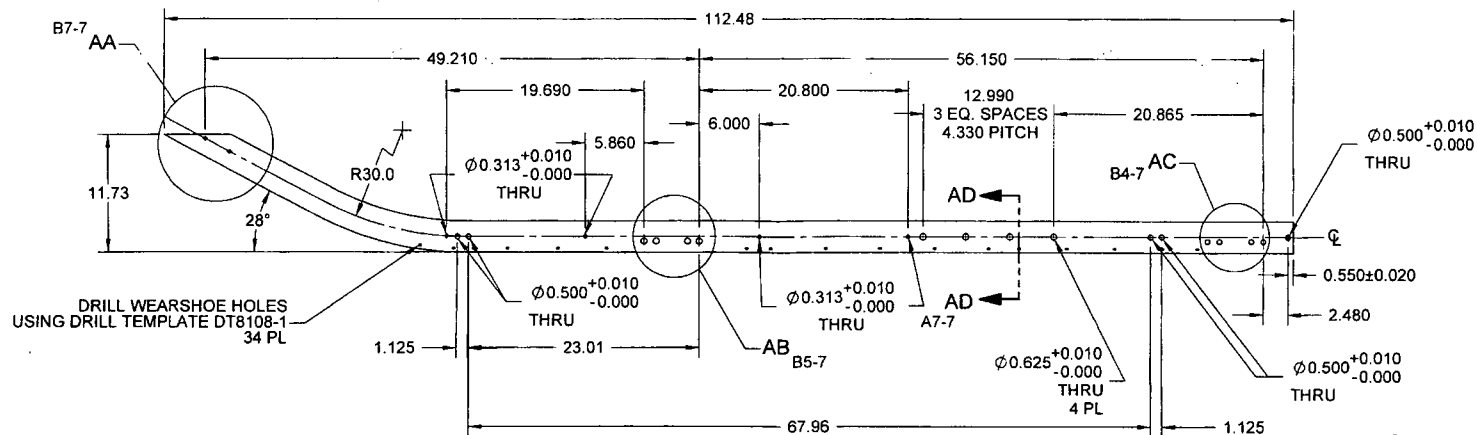
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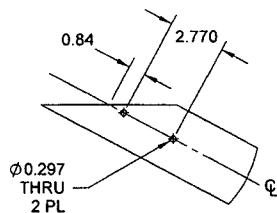
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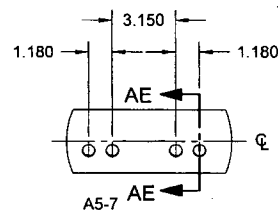
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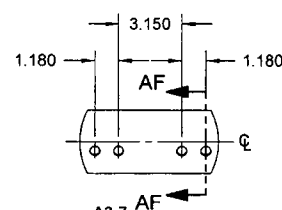
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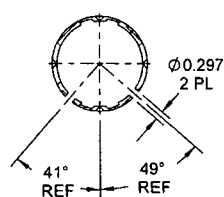
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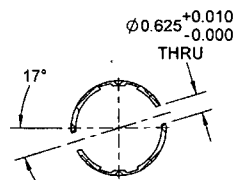
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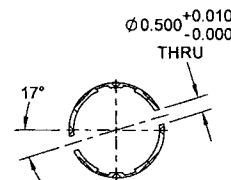
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



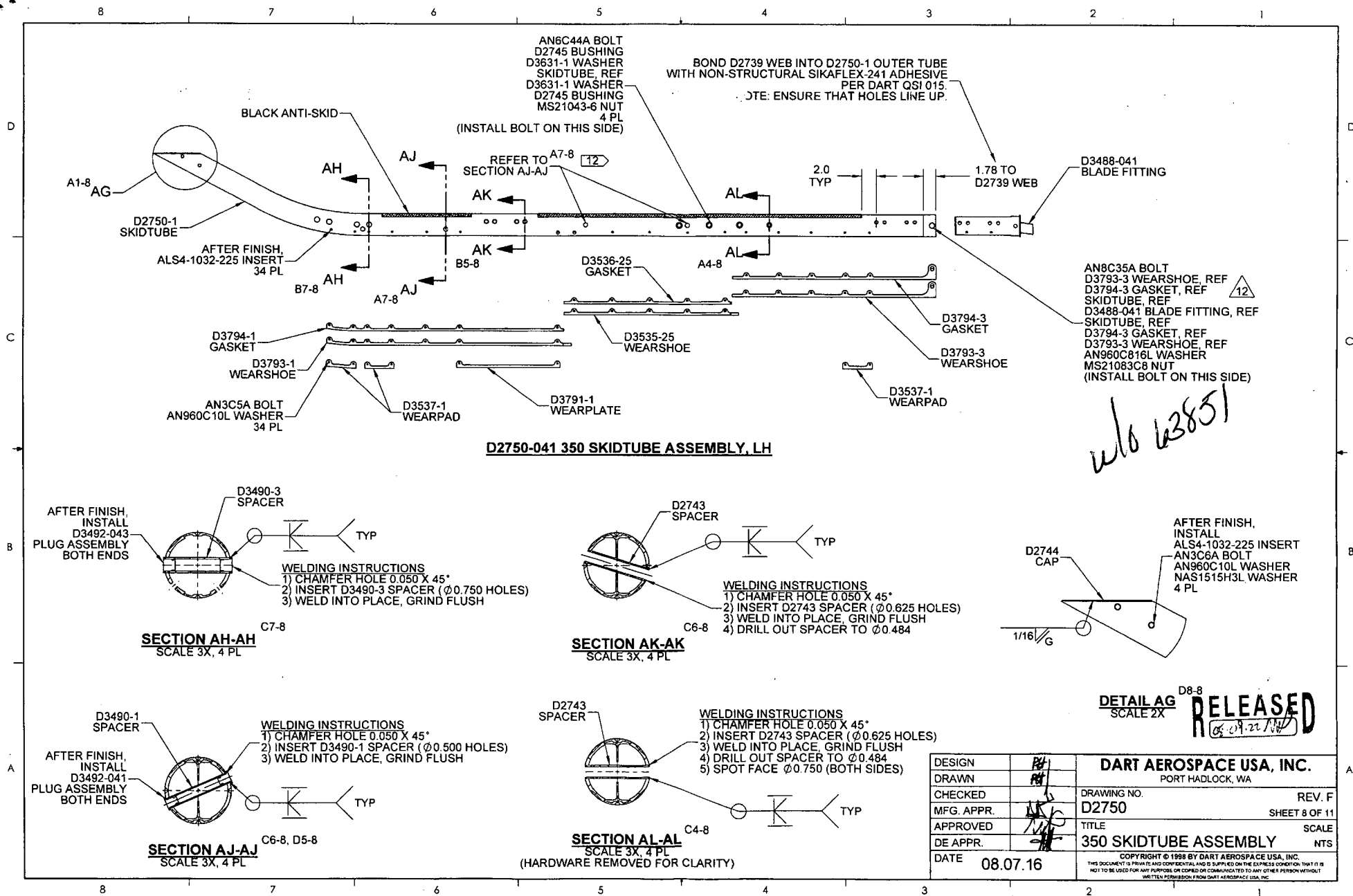
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SCALE 3X, 4 PL



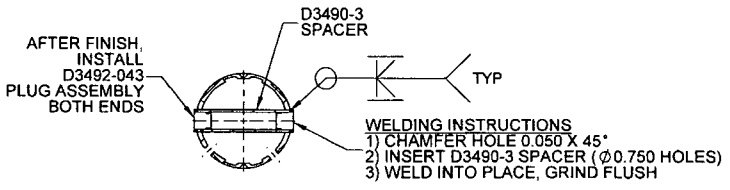
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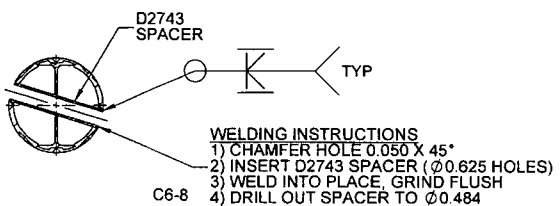
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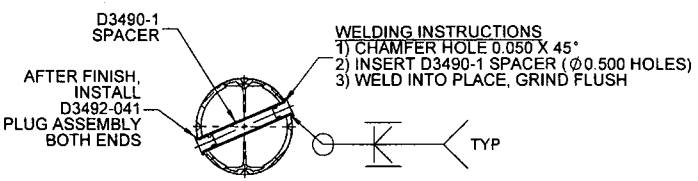
**D2750-041 350 SKIDTUBE ASSEMBLY, LH**



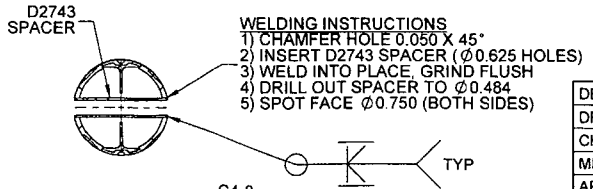
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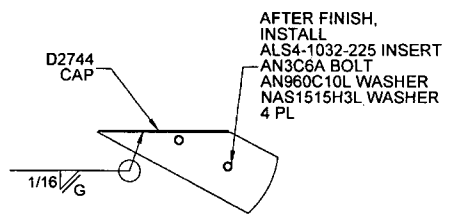
**SECTION AK-AK**  
SCALE 3X, 4 PL



**SECTION AJ-AJ**  
SCALE 3X, 4 PL



**SECTION AL-AL**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



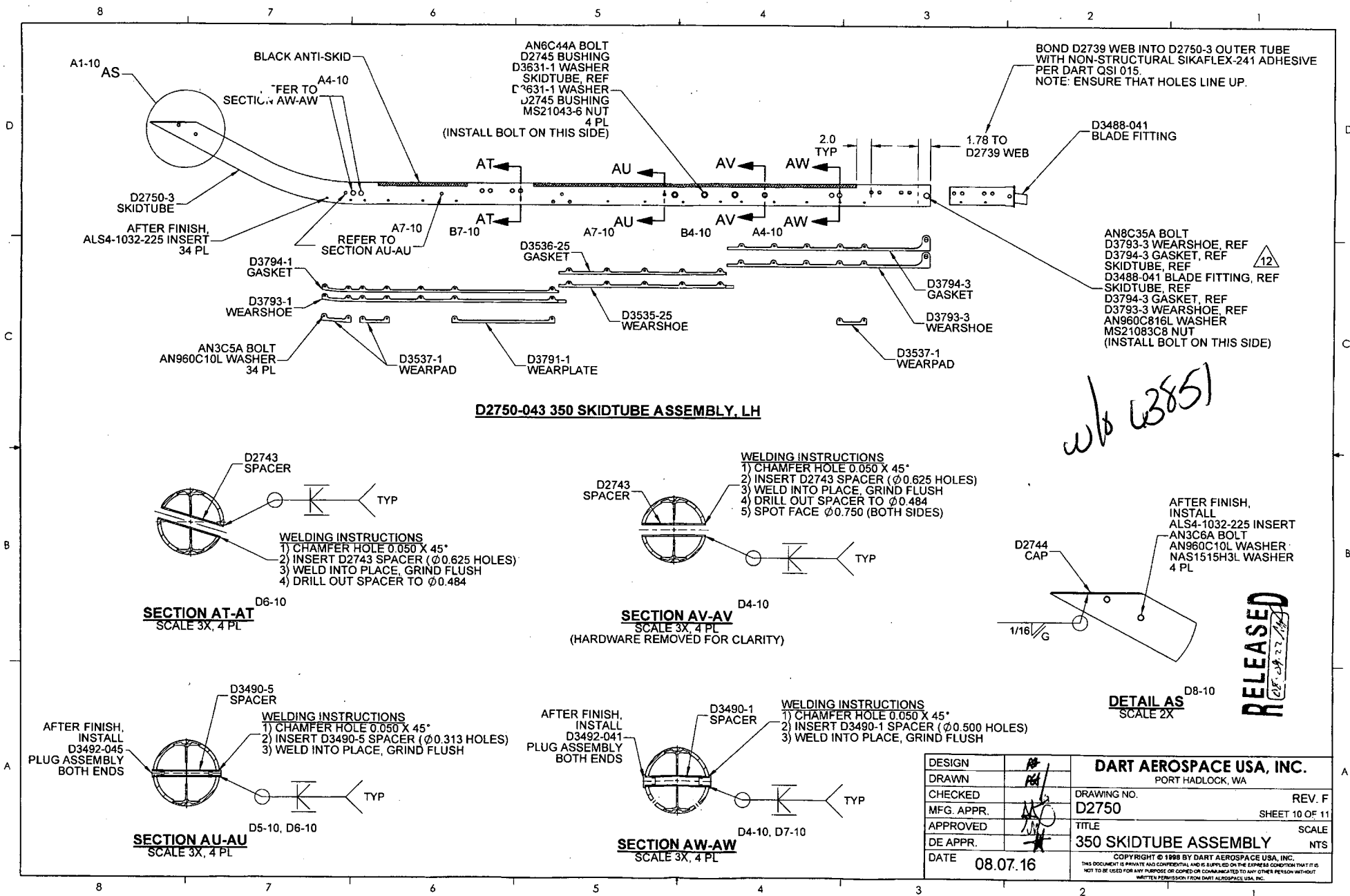
**DETAIL AG**  
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| APPROVED   |          | TITLE   | SCALE         |
| DE APPR.   |          | <b>350 SKIDTUBE ASSEMBLY</b>  | NTS           |
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NO. 239

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 61946 61914  
Part number: D350.636.012  
Description: 350 skid  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[☒] DC[ ]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

UNACCEPTABLE

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier J. D. [Signature] Date of Test Coupon 10.09.30  
Welder Barclay Elliott Date of Test Coupon 10.09.30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld